Date   Wednesday, 15/08/2007 4:00:26 PM
User   Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HANDLE WELDMENT
Job Number	: 33939		
Estimate Number	: 10333		
P.C. Number	: N/A S.O. No. : N/A	Part Number	: D2530
This Issue	: 15/08/2007	Drawing Number	: D2530 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 32573	Material	: N/A
Written By	:	Due Date	: 10/09/2007 Qty: 20 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:E Removed Purchasing 05-11-07 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0750W049	304 RD Tube .750 x .049W

Comment: Qty.:   3.0602 f(s)/Unit   Total :   61.2045 f(s)
Material: 304/316 SS Seamless Tubing 0.75" OD x 0.049" wall(M304TR0.750W.049)
Batch: M105732   SAD   0710-01   (20)

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2536

2-Deburr   SAD   07-10-03   (21)

3.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP   A/10/03 (x 21) counts

4.0	D2534	Lock Plate

Comment: Qty.:   2.0000 Each(s)/Unit   Total :   40.0000 Each(s)
Pick:

QTY	Part #	Description	Batch
2	D2534	Lock Plate	D33990

FC   07 10 24   (x20)

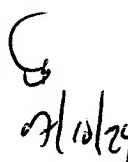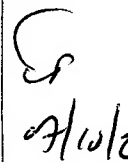|		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301   FC   07/10/24   (20)

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 07/10/24

QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:			Corrective Action Section B				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
07/10/24	# 20	one ROD D2530 scrap Due to the fact that it has a slight Bow/Bend in the center	QS1042	Scrap and Replace	FC 071024	GS 07/10/24	QS1042	GS 07/10/24

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		**Drawing Name:** HANDLE WELDMENT
Job Number: 33939		**Part Number:** D2530

Job Number: |||||||||||||||||||

Seq. #:	Machine Or Operation:	Description :

2-Deburr

6.0   QC9   VISUAL WELDING INSPECTION

||||||||||||| |||||||||||||

Comment: VISUAL WELDING INSPECTION   A 07/10/24 ㉒

7.0   QC5   INSPECT WORK TO CURRENT STEP

||||||||||||| |||||||||||||

Comment: INSPECT WORK TO CURRENT STEP   Er 07/10/24 cowler (4 20)

8.0   POWDER COATING   POWDER COATING

||||||||||||| M /02316 . ||||||||||||| ㉚

Comment: POWDER COATING   ff 07-10-24

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

9.0   QC3   INSPECT POWDER COAT/CHEMICAL CONVERSION

||||||||||||| gs |||||||||||||

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION   07-10-24   ㉒

10.0   PACKAGING 1   PACKAGING RESOURCE #1

||||||||||||| |||||||||||||

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____ STJJY   Pe 7/10/24   ㉒

11.0   QC21   FINAL INSPECTION/W/O RELEASE

||||||||||||| ||||||||||||| ㉚

Comment: FINAL INSPECTION/W/O RELEASE   A 07/10/24

Job Completion ||||||||||||||||||| U 07.10.29

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2530	SHEET 1 OF 1
DATE		TITLE	SCALE
04.12.14		HANDLE WELDMENT	
A	96.06.18	NEW ISSUE	
B	04.12.14	UPDATE NOTES AND DIMENSIONS	

PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE

34.38
(REF)

D2536

D2534
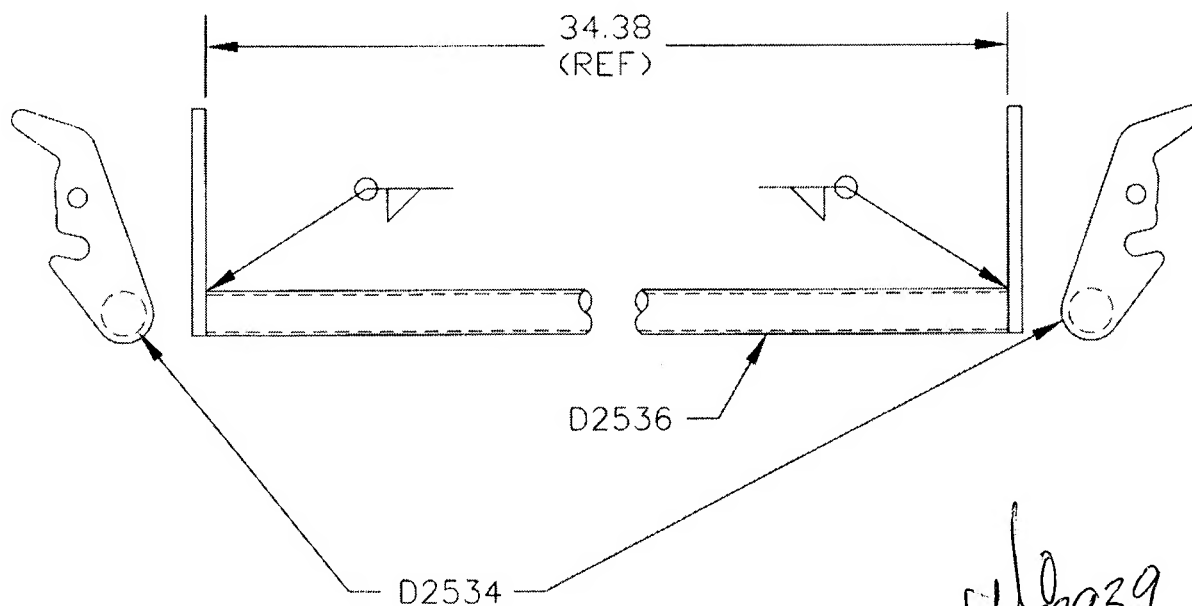
D2530 HANDLE WELDMENT
1) WELD PER DART QSI 004
2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
3) ALL DIMENSIONS ARE IN INCHES
4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED